



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 201223



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		10/28/19	0.00	0.65	Skidtubes - Bend		MGG
120	Skidtubes - 2 - B4B	1 pcs		10/28/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		MGG
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		10/28/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S227817



Part: D205-634-041

Job No: 201223

Serial No/Batch: S227817

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2 FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

140 Skidtubes - 3 - B4B	1 pcs	10/28/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	10/28/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	10/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/28/19	0.00 1.31	Handfinish - 1 - 1 - B4B	BEB 19-11-15
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

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				B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180	Powdercoat - 1 White G(A)- B4B	1 pcs	10/28/19	0.00 0.34	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
190	QC 3	1 pcs	10/28/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
200	Handfinish - 4-1-Assembly- B4B	1 pcs	10/28/19	0.00 1.00	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B
					Handfinish - 4 - 13 - B4B
					Handfinish - 4 - 14 - B4B
					Handfinish - 4 - 15 - B4B
					Handfinish - 4 - 2 - B4B
					Handfinish - 4 - 3 - B4B
					Handfinish - 4 - 4 - B4B

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					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
210 QC 5	1	10/28/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
220 Packaging 3-1 - Stock - B4B	1	10/28/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	

DAS

NOV 22 2019 68

9-89

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	DAS
				Packaging 3 - 34 - B4B	21
				Packaging 3 - 35 - B4B	9-89
				Packaging 3 - 36 - B4B	NOV 29 2019
225 DC - 1 - B4B	1	10/28/19	0.00 0.00	DC - 1 - B4B	DAS
	pcs			DC - 2 - B4B	21 NOV 29 2019
230 QC 21 - FG	1	10/28/19	0.00 0.00	QC 21 - FG - 21	9-89
	pcs			QC 21 - FG - 70	NOV 29 2019
				QC 21 - FG - 53	DAS

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 1:00 OVEN TEMPERATURE: 328°

FINISH TIME: 1:30 12/11/86

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 520062. Sikaflex expire date: 20-1-22 Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 520062. Sikaflex expire date: 20-1-22 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5209362

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skid tubes - Bend - 1	5214193
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skid tubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skid tubes - 3 - B4B	5184047
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209141
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5228681
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5229062
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5043417
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196397
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5207800
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208675
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208809
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5225629
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178379

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	11	0
140-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	20	700	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,502	0
	AN3-5A	2	272	0
	AN3C4A	50	484	0
	D2594-1	16	59	0
	D2594-3	16	466	0
	D2855	1	78	0
	D3564-11	1	9	0
	D3564-13	1	26	0
	D3564-5	1	19	0
	D3564-9	1	18	0
	NAS1149C0332R	50	2,501	0
	NAS1149D0332J	2	1,766	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2680-041	SKIDTUBE ASSEMBLY
2		X		D2680-045	SKIDTUBE ASSEMBLY
3			X	D2680-047	SKIDTUBE ASSEMBLY
4			X	D2680-048	SKIDTUBE ASSEMBLY
20	1	1	1	D2680-110	ENTRUSION
21			16	D2670	BUSHING
22	1	1	1	D2678-3	STEP
23		4		D2679	SPACER
24	16	16	8	D2684-1	PLUG
25	16	16	8	D2684-3	O-RING
26	1	1	1	D2686	300 WEB
27	1	1	1	D2685	AFT CAP
28	1	1	1	D2684-5	WEARSHOE
29	1	1	1	D2684-6	WEARSHOE
30	1	1	1	D2684-11	WEARSHOE
31	1	1	1	D2684-13	WEARSHOE
32	20	20	24	D4002-1	SPACER
33			1	D4003-041	WEARPLATE ASSEMBLY
34			1	D4004-045	WEARPLATE ASSEMBLY
35			1	D2001-1	PLYD WEARPLATE
36			1	D2001-3	AFT WEARPLATE
50	50	50		AL37-1032-150 or AK57-1032-150 or AK54-1032-150 or AELS-1032-150	INSERT
51	50	50		ANSC4A	BOLT
52	2	2	2	AN5-5A	BOLT
53			8	AN4-5A	BOLT
54	50	50		NAS1140C0330R	WASHER (AN400C10L)
55	2	2	2	NAS1140D0330J	WASHER (AN400D10L)
56			8	NBS1042-4	NUT (OR NBS1042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART Q81 008 4.1 PRIOR TO INSERTING D2680 WEB
POWDER COAT (441-047-048) GLOSS WHITE (REF 4.3.4.1) PER DART Q81 008 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART Q81 008 4.4.
- 3) TOLERANCES ARE PER DART Q81 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCLUDE UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.008 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2680-041 = 33.7 lbs
D2680-045 = 33.7 lbs
D2680-047 = 48.1 lbs
D2680-049 = 32.0 lbs
- 8) WELDING PER DART Q81 004.
- 9) INSERT D2680 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART Q81 018 BEFORE
BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 80 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.300 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR217 & DTR607 ONLY FOR D2680-041-045 TO LOCATE AND DRILL
20.307 HOLES FOR WEARSHOE INSERTS. INSTALL AL37-1032-150 PER SECTIONS B-3 AND F-F (60
PLACES) AFTER FINISH. INSTALL ANSC4A BOLTS AND NAS1140C0330R WASHERS WITH
SIKAFLEX-241-301.
- 12) INSERT D2684-1 PLUG CAN D2684-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE AFTER
FINISH (16 PLACES FOR D2680-041-045 AND 8 PLACES FOR D2680-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2680 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

H	SHEET : PL DELETE D2680-14-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -046 -047 WEIGHT UPDATED PER D2680-048	AJS	14.04.09
F	INCORPORATE DED D2680-E-1 PER PART3-218	DC	13.06.20
E	ADD D2680-047 (ZN C4-7) AND D2680-7 (ZN B3-8) INCLUDED DED D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR607 WAS TO D2677-305 (ZN C4-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE DED 9124 9169	PH	07.04.09
C	REDRAWN, INCLUDED DED 9094 9097	CP	06.08.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.08.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	13		
MFG. APPR.	D2680		
APPROVED	TITLE		
DE APPR.	205 SKIDTUBE ASSEMBLY		
DATE	17.06.09		

RELEASED

2017 JUL 05 10
50077-5101

POP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

FOR IDENTIFICATION

NOTICE

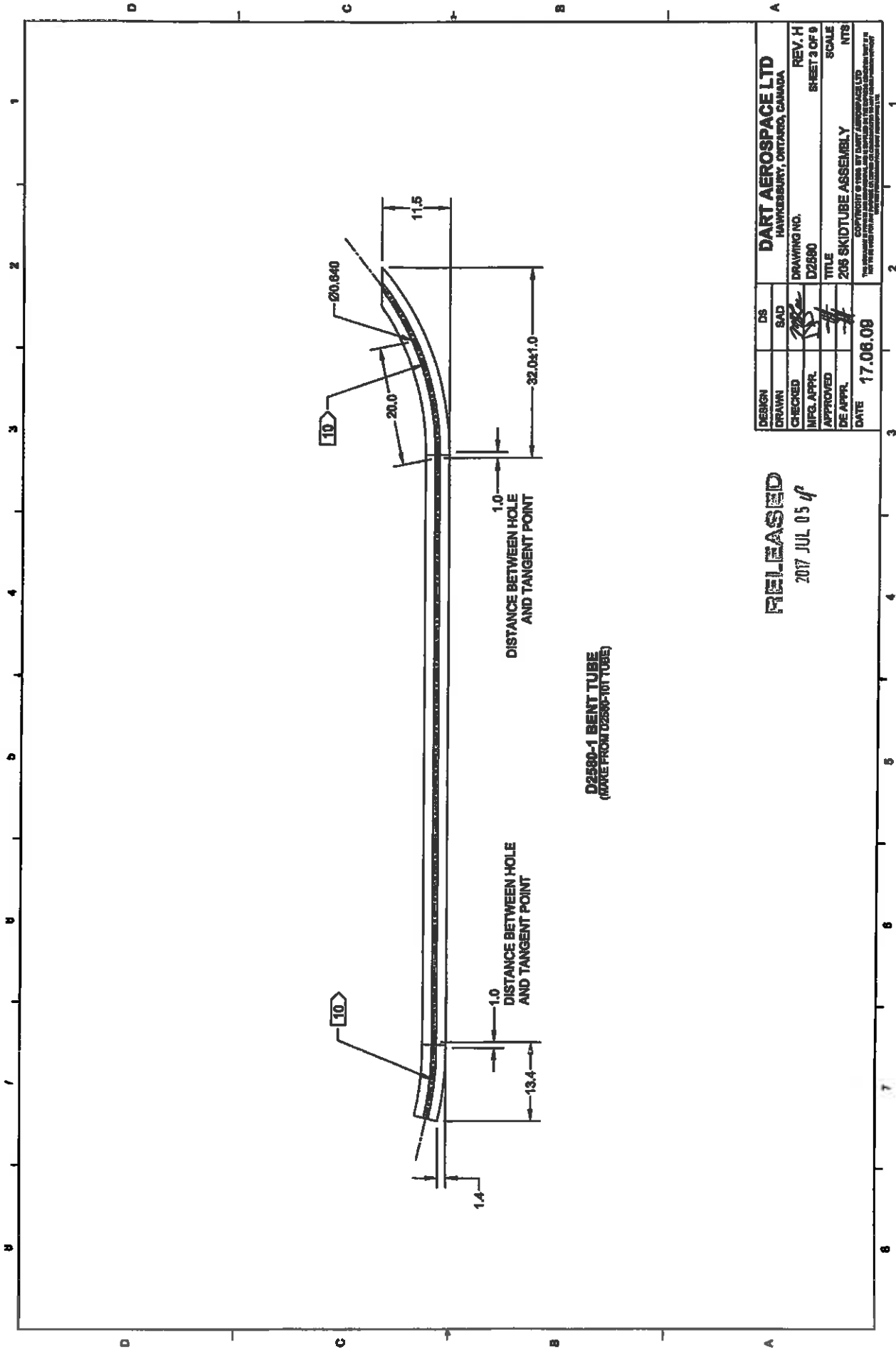
ORDER

2017.2.23 MJS

19-09-27

RELEASED

2017 JUL 05 10
50077-5101



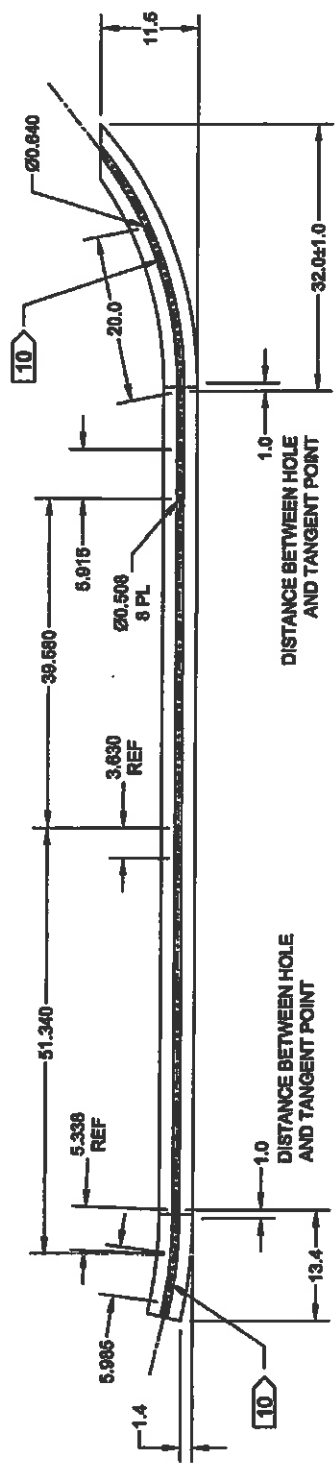
D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05 4p

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKSBURY, ONTARIO, CANADA
CHECKED	13	DRAWING NO. D2580
REGL. APPR.	13	REV. H
APPROVED	13	SHEET 3 OF 9
DE APPR.	13	TITLE 208 SKIDTUBE ASSEMBLY
DATE	17.08.08	SCALE NT8

CONFIDENTIAL TO DART AEROSPACE LTD
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1 2 3 4 5 6 7 8

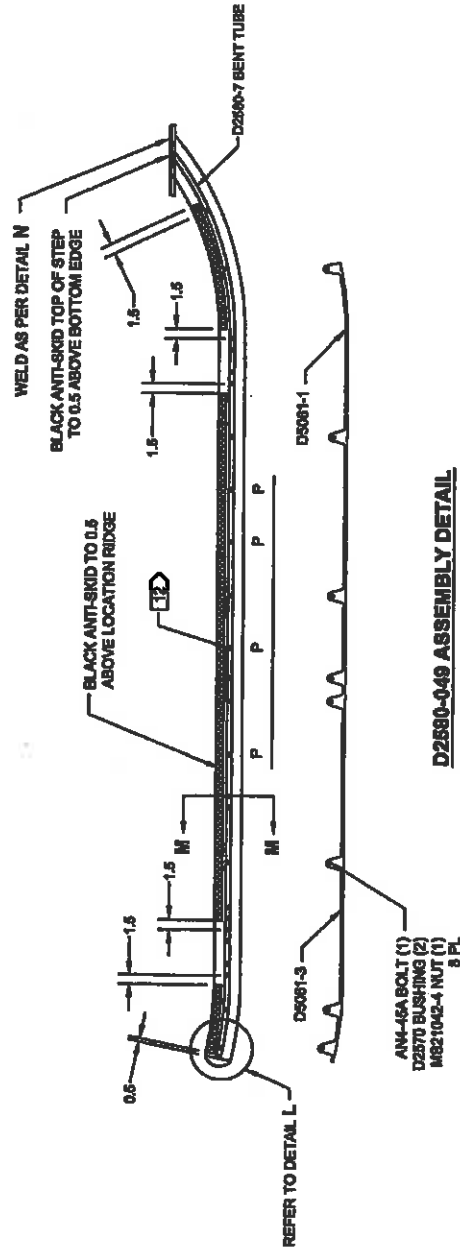


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

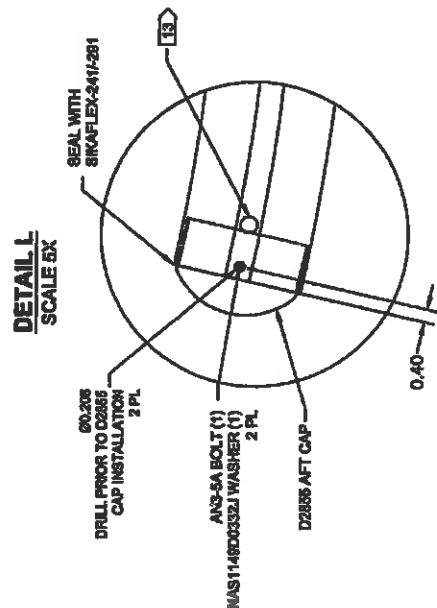
RELEASED
2017 JUL 05 10

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HANWESBURY, ONTARIO, CANADA
CHECKED	REV. H	REV. H
MFG. APPR.	D2580	SHEET 6 OF 8
APPROVED	TITLE	SCALE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY
		NTS
		EXPERIMENT 1000 BY DART AEROSPACE LTD
		THE DRAWING IS APPROVED FOR MANUFACTURE AND IS TO BE USED IN THE MANUFACTURE OF THE SKIDTUBE ASSEMBLY
		DATE OF APPROVAL 17.06.09

1 2 3 4 5 6 7 8



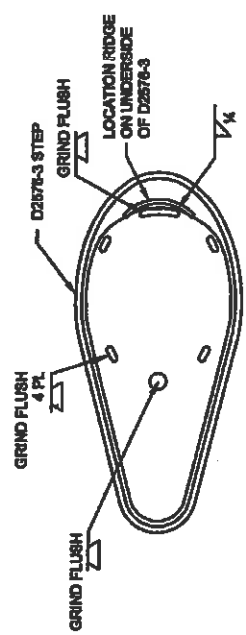
D2580-049 ASSEMBLY DETAIL



SECTION M-M SCALE 5X



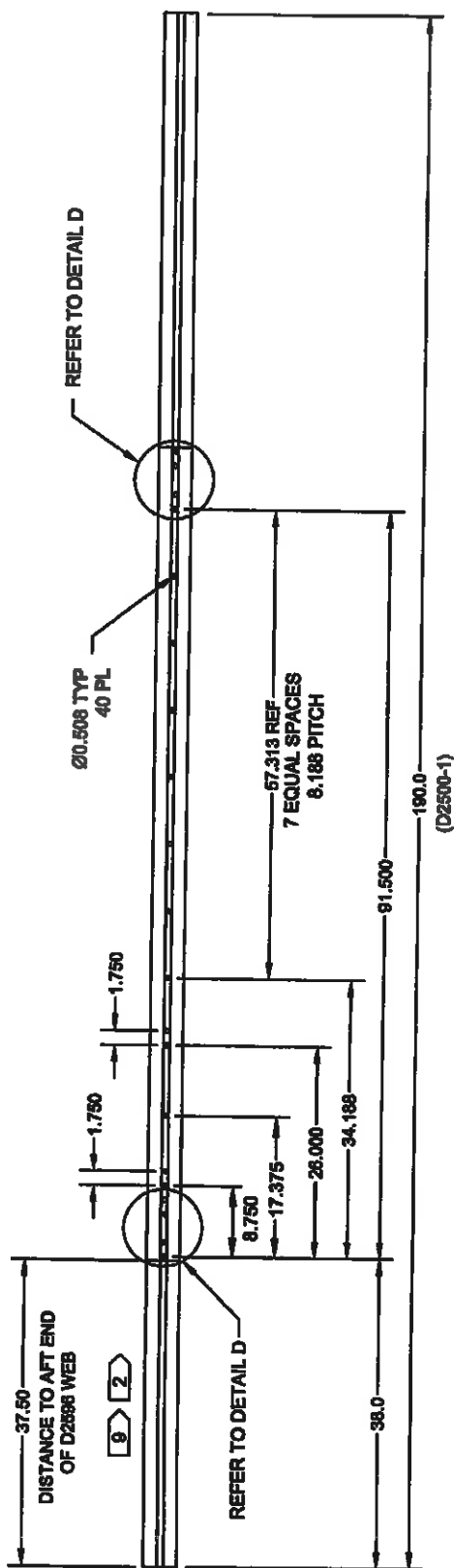
DETAIL N SCALE 5X



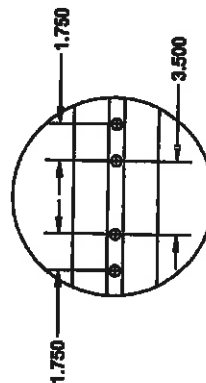
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 90.688 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER Q81 002
3. TRIMGRIND FLUSH PER Q81 002

RELEASED
2017 JUL 05 40

DESIGN	DS	SAID	DART AEROSPACE LTD
DRAWN	CHECKED	INFO. APPR.	HARRISBURG, ONTARIO, CANADA
APPROVED	DATE	17.06.09	DRAWING NO. D2580
TITLE	205 SKIDTUBE ASSEMBLY	REV. H	SHEET 7 OF 9
SCALE	NTS		



D2580-101 TUBE



DETAIL D
SCALE 5X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAMILTON, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2580
APPROVED		REV. H
DATE	17.06.09	SHEET 9 OF 9
		TITLE
		205 SKIDTUBE ASSEMBLY
		SCALE
		NTS
		NOTES
		1. SEE DETAIL D FOR HOLE PATTERN AND DIMENSIONS FOR THE SKIDTUBE ASSEMBLY.
		2. SEE DETAIL D FOR HOLE PATTERN AND DIMENSIONS FOR THE SKIDTUBE ASSEMBLY.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____		DISPOSITION				DEPARTMENT/PROCESS																																																																																	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																	
Date :	Sequence #:	QTY Affected :		MRB (QSI042)																																																																																			
Description Work Order Deviation		Disposition																																																																																					
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